

The Invention Claimed Is

Sub 1. A method of making an information-recording medium having an indelible watermark comprising the steps of:

providing a mark on a back surface of a stamper, wherein said back surface of said stamper is opposite to a front surface, said front surface comprising a pattern of pits and lands; and

forming a substantially transparent disc using said stamper, said disc having a first substantially planar surface and a second surface opposite to said first surface, wherein in said forming said pattern of pits and lands is transferred from said front surface of said stamper to said second surface of said disc and said mark on said back surface of said stamper forms an indelible watermark on said second surface of said disc.

2. The method of claim 1 wherein said forming comprises the step of:

transferring both of said pattern of pits and lands from said front surface of said stamper and said mark from said back surface of said stamper to said second surface of said disc in a replication process.

3. The method of claim 2 wherein said replication process comprises injection molding.

4. The method of claim 2 wherein said replication process comprises injection-compression molding.

5. The method of claim 2 wherein said replication process comprises compression molding.

6. The method of claim 1 wherein said providing comprises laser-scribing.

7. The method of claim 1 wherein said providing comprises etching.

8. The method of claim 1 wherein said providing comprises diamond-scribing.

9. The method of claim 1 wherein said providing comprises use of a mechanical tool.

10. The method of claim 1 further comprising sanding the back of the stamper after said providing.

11. The method of claim 1 wherein said providing comprises depositing said mark subsequent to sanding the back of said stamper.

12. An information-recording medium having an indelible watermark produced according to the method of claim 1.

13. The information-recording medium according to claim 12 wherein said indelible watermark is superimposed onto the pits and lands on the second surface of the disc.

14. The information-recording medium according to claim 12 wherein said indelible watermark

0996315-11801
TOP SECRET

is located in a region of the second surface of the disc that is free from pits and lands.

15. The information-recording medium according to claim 12 wherein said indelible watermark comprises lettering.

16. The information-recording medium according to claim 12 wherein said indelible watermark comprises a graphical image.

17. The information-recording medium according to claim 12 wherein said indelible watermark comprises a trademark.

18. The information-recording medium according to claim 12 wherein said indelible watermark is machine readable.

19. The information-recording medium according to claim 12 wherein said indelible watermark is visible under normal light conditions.

09996315.112001
FOOT ST 96660